

ABSTRACT OF THE DISCLOSURE

The peripheral length dimension of the outer peripheral surface of drums is set equal to the width dimension of body ply materials used for tires or integral multiples thereof. The wrapping length of the wrapper in the direction of the length of the drum is set equal to the length dimension of the body ply materials used for tires. A ribbon of predetermined width E dimension in the form of a cord having a rubber covering applied thereto is produced. The ribbon is spirally wound on the outer peripheral surface of the drums and the lateral edges of the ribbon are bonded together, thus producing the wrapper. The wrapper is cut along a gentle curve which is substantially orthogonal to the direction of the length of the ribbon, thus providing the body ply materials.